

Work Order ID 80067

Thursday, February 09, 2012 12:43:41 PM

80067

Page 1

Quality Control

EL 12-3-29 (X3)

PC 12.03.30

 $3x$ ~~ϕ~~

S1263/30

B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80067***80067***

Page 2

Thursday, February 09, 2012 12:43:41 PM

Item ID: D4324-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Support Assembly

Start Date: 2/10/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

ST 139C

0.00

130

Packaging

Memo

0.00

Packaging

3x SP 12-03 30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/12
02-03-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 80067

Parent Item: D4324-043

Parent Item Name: Arm Support Assembly

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 11.04.04 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C3 Castellated Nut		Purchased	No			100	Each	26.0000	1	3		12-3-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		26							
				114714		26							
D4324-3 Support Plate		Manufactured	No			100	Each	6.0000	1	3		12-3-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139E		6							
				79135		6							
D4324-7 Tube		Manufactured	No			100	Each	0.0000	1	3		12-3-29	

80068 x 3

Dart Aerospace Ltd

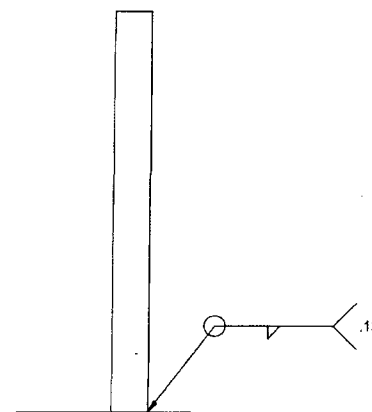
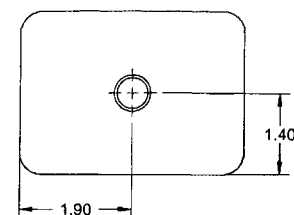
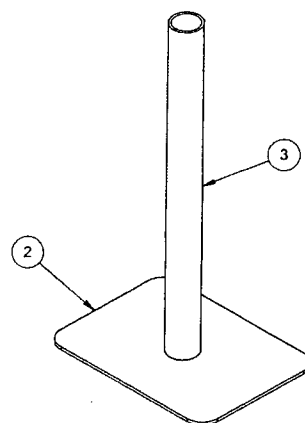
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ITEM	QTY	PART	DESCRIPTION
1	X	D4324-041	ARM REST ASSEMBLY
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

RELEASED
2011-04-86
JWH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.36 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4324	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	11.01.31	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

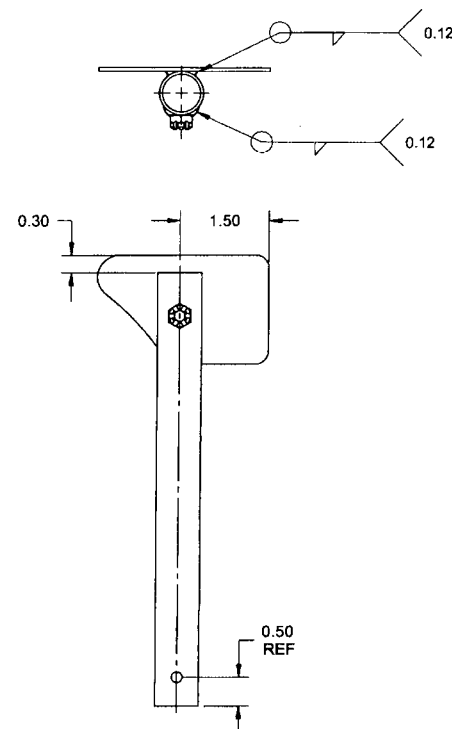
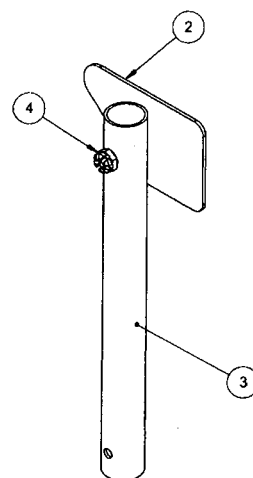
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

RELEASED
2011-04-08
MM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4324	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE VRD PARTS	SHEET 2 OF 5
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DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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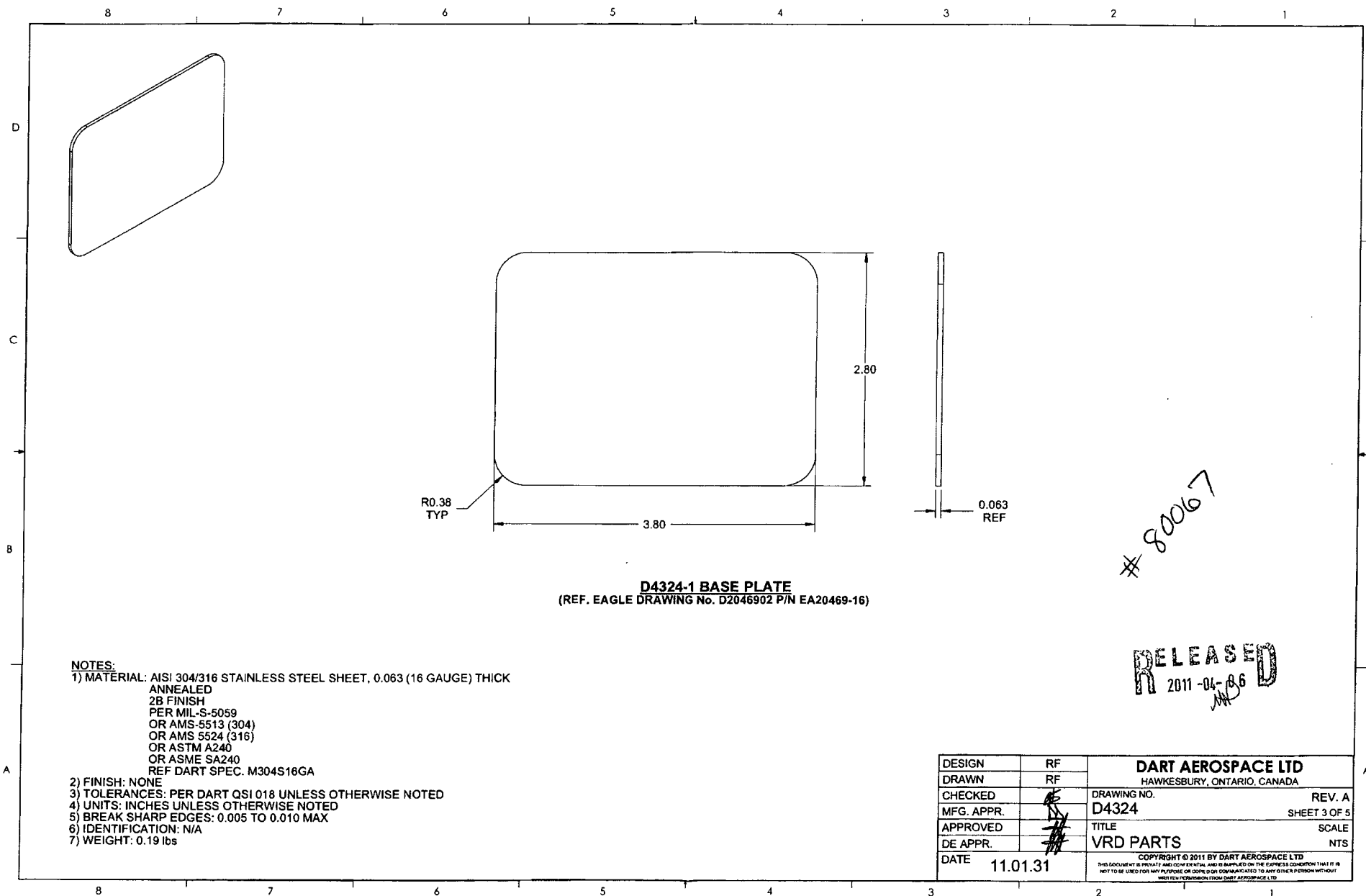
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NOTE: Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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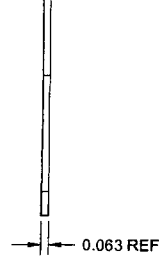
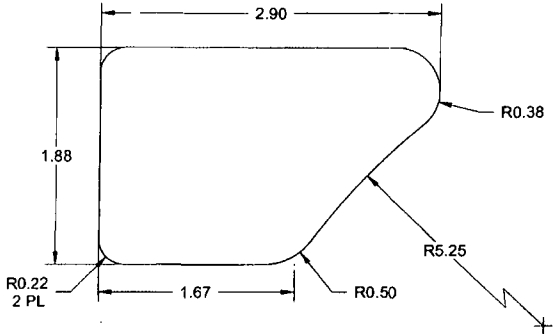
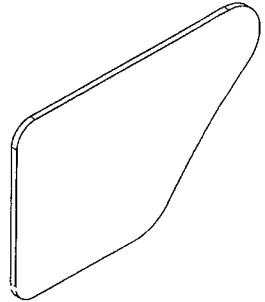
8 7 6 5 4 3 2 1

D

C

B

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

80067

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D4324	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE VRD PARTS	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

8

7

6

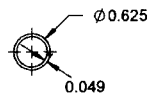
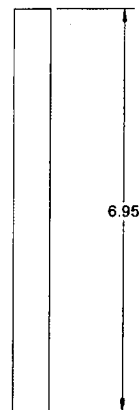
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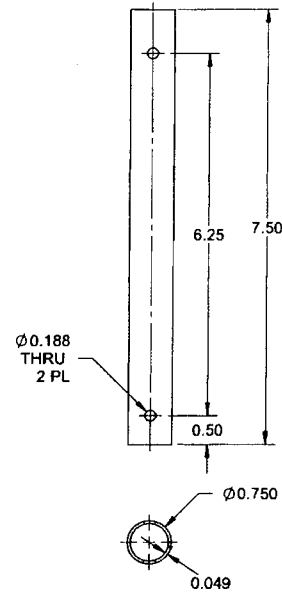
3

2

1

**D4324-5 TUBE**

(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

**D4324-7 TUBE**





(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

80067

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4324	REV. A
MFG. APPR.		TITLE	SHEET 5 OF 5
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DE APPR.			NTS
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